

(C)

PLOT SCALE:

1=1

DWG. SCALE: 1

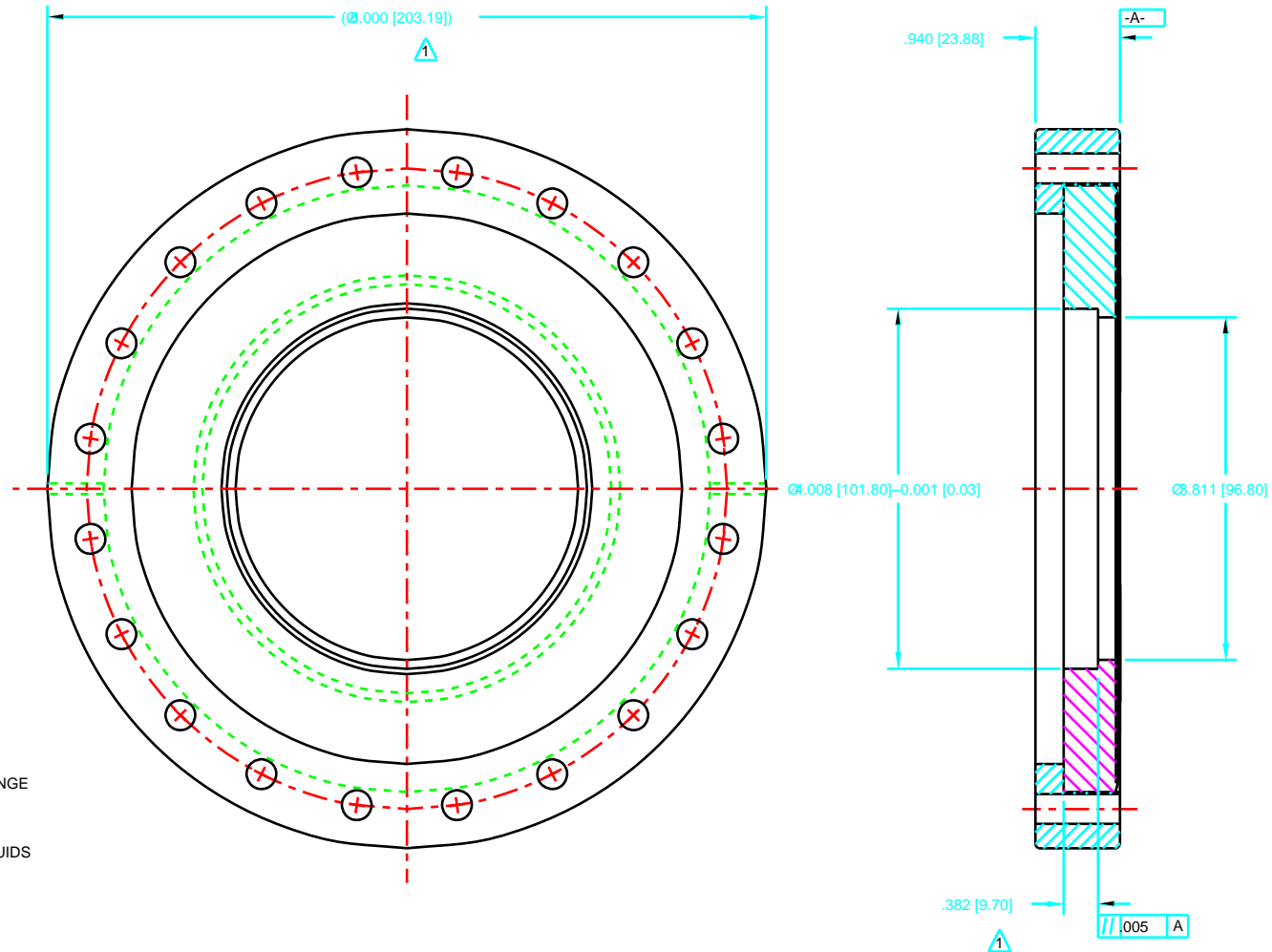
A1672001

4

3

2

1



NOTES:

1. MAKE FROM MDC'S 8" O.D. ROTATABLE FLANGE CAT. #100030
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

1	.382 [9.70] WAS .412 [10.70]			
1	Ø.000 [20.32] WAS Ø.000 [152.40]	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM		DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION		MATERIAL / SPEC		QTY	
PARTS LIST									
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				THIS DRAWING IS THE PROPERTY OF					
TOLERANCES				ARGONNE NATIONAL LABORATORY					
DECIMALS		ANGULAR		<div>ADVANCED PHOTON SOURCE</div> <div>L5 APS UNDULATOR WHITE BEAM H & V SLITS RIGHT END VACUUM FLANGE</div>					
X - .03 [1.7620]		- .25							
.XX - .01 [0.25]									
.XXX - .005 [0.127]									
SURFACE ROUGHNESS		125							
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.									
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1									
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5									
DO NOT SCALE DRAWING									
LOG NUMBER				A1672001					
DRAWN BY				DATE	CHIEF DESIGN ENGINEER	DATE	TITLE		
MUSCIA				3/3/94	D. SHU	3.25.94			
CHECKED BY					GP LEADER				
J. WOTHE				3/22/94	T.M. KUZAY	4/9/94			
DESIGNER					PROJECT MGR.				
SHU/MUSCIA				3/25/94					
RESPONSIBLE ENGINEER					APPROVED/RELEASED				
D. SHU				3/25/94					
MATERIAL				SCALE					
SEE ABOVE				1:1					
				SHEET		1 of 1		SIZE	
						C		DRAWING NUMBER	
								P4105091505-230002-01	